

Monday, 11/08/2008 2:46:41 PM
da Lacelle

Process Sheet

Number	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT DOOR ASSEMBLY
Estimate Number	: 41139	Part Number	: D350588041
P.O. Number	: 12103	Drawing Number	: D2445, D350-588 P5-6
This Issue	: 11/08/2008 S.O. No. :	Project Number	: N/A
Prsht Rev.	: NC	Drawing Revision	: D,D
First Issue	: / / Type : SMALL /MED FAB	Material	:
Previous Run	: 36869	Due Date	: 12/09/2008 Qty: 1 Um: Each
Written By	:		
Checked & Approved By	: <u>JUD 08.8.11</u>		
Comment	: Est P 04.02.04 Reformat KJ/DS		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D350-588-041 CHG003

2.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 6919

Description: D2445 Baggage Door

Supplier: Delastek

Ship to Delastek (1) D0588-041 label

Certification of Conformity and process sheet from Delastek is required.

3.0	D2445	Aft Door, 350
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Aft Door

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure Certificate of Conformity & Process Sheet are attached

5.0	QC6	DIMENSIONAL CHECK
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Comment: INSPECT WORK TO CURRENT STEP

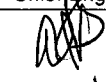



Inspect as per Dwg D2445.

Audit process sheet.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-588-041 PAR #: N/A Fault Category: Supplier/Defect NCR: Yes No DQA: D Date: 08/12/14
 QA: N/C Closed: _____ Date: _____

NCR: <u>08-096</u>		WORK ORDER NON-CONFORMANCE (NCR)					
DATE	STEP	Description of NC Section A	Corrective Action Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng			
06-10-14	5.0	Prior to ass'y it was noticed that the foam core was very visible on the outside of the door.	 08/10/14	doors are returned, and are being replaced per NCR 08-096 doors Door replacement.	 08-12-14	 08/10/14	 06/10-14

NOTE: Date & initial all entries

Date: Monday, 11/08/2008 2:46:41 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT DOOR ASSEMBLY

Job Number: 41139

Part Number: D350588041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2143

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2143 Hinge Doubler 33382

SS 08/12/15 (X)

7.0

D2144

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2144 Hinge Doubler 34465

Batch not comp

SS 08/12/15 (X)

8.0

D2463

Seal



Comment: Qty.: 7.2500 f(s)/Unit Total : 7.2500 f(s)

Neoprene Seal

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2463-0870 1/2" Foam Seal 41121

SS 08/12/15 (X)

9.0

D2585

Mounting Channel



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2585 Latch Clamp 43922

SS 08/12/15 (X)

10.0

D2586

Door Latch



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2586 Latch 39783

SS 08/12/15 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/08/2008 2:46:41 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT DOOR ASSEMBLY

Job Number: 41139

Part Number: D350588041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D2621

Latch Plate, 350 Spacepod



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Latch Plate

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2621 Latch Plate

33894

SS 08/12/15 (X)

12.0

D28571

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2857-1 Lower Hinge Bracket

38680

SS 08/12/15 (X)

13.0

D28572

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2857-2 Upper Hinge Bracket

39786

SS 08/12/15 (X)

14.0

AN526C832R9

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 AN526C832R9 Screw

109545

SS 08/12/15 (X)

15.0

AN960JD8

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 AN960JD8 Washer

M109545

SS 08/12/15 (X)

16.0

AN960JD10

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960JD10 Washer

M109061

SS 08/12/15 (X)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT DOOR ASSEMBLY

Job Number: 41139

Part Number: D350588041

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

MS21042L08

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 MS21042L08 Nut (or -08)

M109174

SS 08/12/15 (X)

18.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 MS21042L3 Nut (or -3)

109031

SS 08/12/15 (X)

19.0

MS27039115

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 MS27039-1-15 Screw

M108165 M109321

SS 08/12/15 (X)

20.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble all of the above parts as per Dwg D350-588

BL 08-12-23 (X)

21.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-12-24 (X)

22.0

D2150

Packer Doubler, Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2150 Hinge Packer

39780

SS 08/12/15 (X)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: AFT DOOR ASSEMBLY

Job Number: 41139

Part Number: D350588041

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

D2151

Packer Doubler, Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2151

Hinge Doubler

36844

SS 08/12/15 (X)

24.0

D2153

Door Prop



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2153

Gas Spring Assy

41421

SS 08/12/15 (X)

25.0

D2154

Stud Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2154

Stud Bracket

39781

SS 08/12/15 (X)

26.0

D2237

Striker Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Striker Plate

Pick: Assembly Kit

Qty Part Number

Description

Batch

2 D2237

Striker Plate

41163

SS 08/12/15 (X)

27.0

D2461

Neoprene "D" Seal



Comment: Qty.: 7.2500 f(s)/Unit Total : 7.2500 f(s)

Neoprene "D" Seal

Pick: Kit Picking

Qty Part Number

Description

Batch

1 D2461-0870

Neoprene 'D' Seal

39782

SS 08/12/15 (X)

28.0

D2589

Keys, Key Chain, 350 Hinge



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2589

Keys, Key Chain

36814

SS 08/12/15 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: AFT DOOR ASSEMBLY

Job Number: 41139

Part Number: D350588041

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

D28581

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2858-1

Lower Hinge Bracket

39787

SS 08/12/15 (X)

30.0

D28582

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2858-2

Upper Hinge Bracket

39788

SS 08/12/15 (X)

31.0

AN526C832R8

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN526C832R8 Screw

9216 M108335

SS 08/12/15 (X)

32.0

AN526C1032R7

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 AN526C1032R7

Screw

M108940

SS 08/12/15 (X)

33.0

AN960JD8

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Washer

Pick: Kit Picking

Qty Part Number

Description

Batch

16 AN960JD8

Washer

M109545x15

SS 08/12/15 (X)

34.0

AN960JD10

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Pick: Kit Picking

Qty

Part Number

Description

Batch

2 AN960JD10

Washer

M109601

SS 08/12/15 (X)

W/O: ,		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT DOOR ASSEMBLY

Job Number: 41139

Part Number: D350588041

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

MS20470AD45

Rivet, Universal Head



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty Part Number

Description Batch

18 MS20470AD4-5

Rivet

M106918

Batch not in comp.

SS 08/12/15 (X)

36.0

MS20426AD34

RIVET



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description Batch

12 MS20426AD3-4

Rivet

M105978

SS 08/12/15 (X)

37.0

MS21042L3

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Pick: Kit Picking

Qty Part Number

Description Batch

4 MS21042L3

Nut (or -3)

M109031

SS 08/12/15 (X)

38.0

MS270390811

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 MS27039-0811 Screw

M108335

SS 08/12/15 (X)

39.0

MS21042L08

Nut



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Nut

Pick: Kit Picking

Qty Part Number

Description Batch

10 MS21042L08

Nut (or -08)

M109174

SS 08/12/15 (X)

Pick kit is in stock.

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/08/2008 2:46:42 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT DOOR ASSEMBLY

Job Number: 41139

Part Number: D350588041

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08.12.25

41.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Rev D

AS 08/12/30

(X)

42.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

209/01/05

Job Completion



12.01.05

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

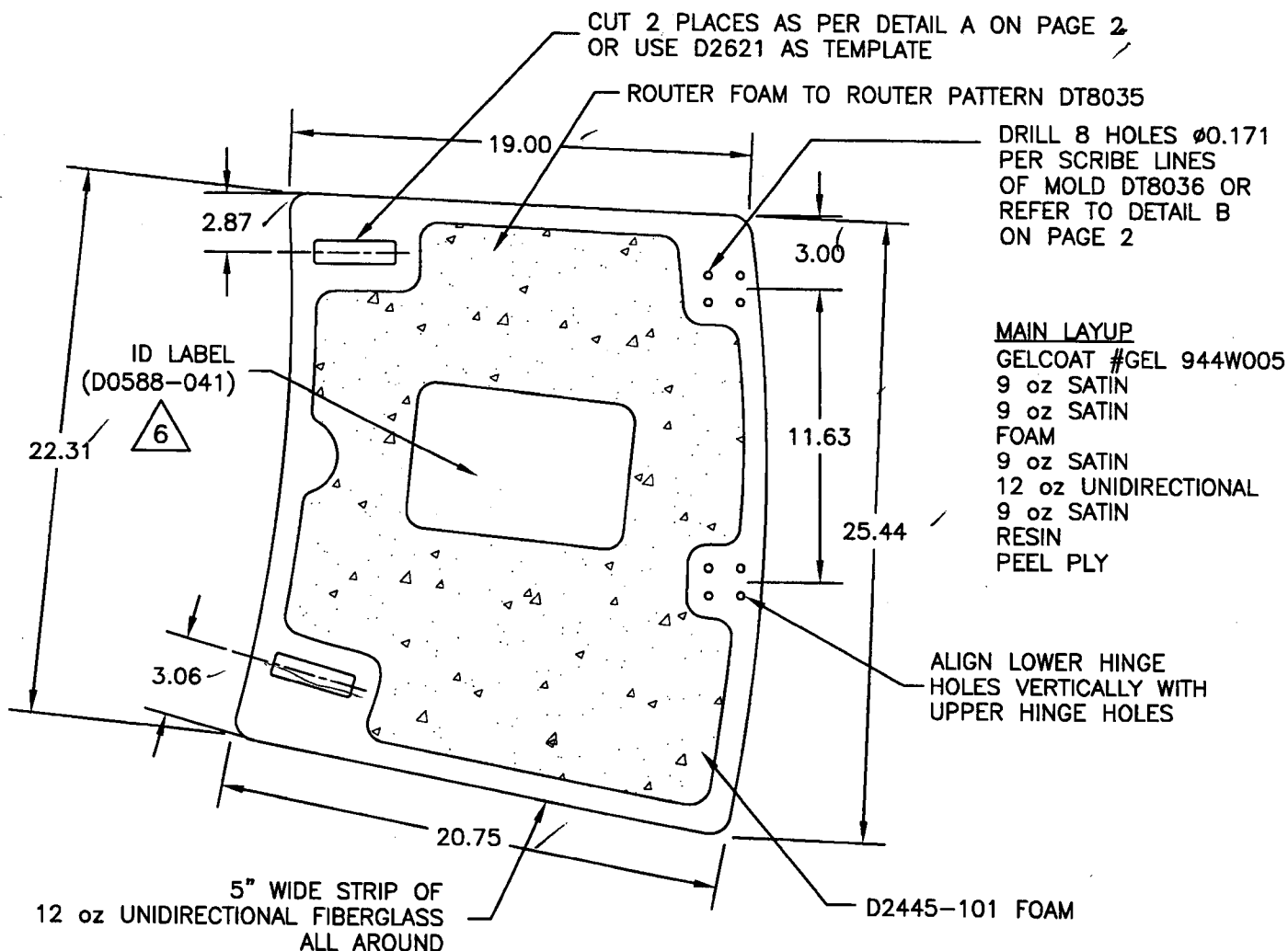
NOTE: Date & initial all entries

DART

DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2445	REV. D SHEET 1 OF 2
DATE 06.06.09	TITLE AFT BAGGAGE DOOR		SCALE 1:7
A	97.07.15	NEW ISSUE	
B	02.01.24	ADD D2621; D2445-101	
C	04.02.09	REMOVE D2621; UPDATE NOTES	
D	06.06.09	ADD DIMENSIONS TO PERIMETER	

RELEASED

06.11.13

**NOTES:**

- 1) USE MOLD DT8036 FOR DOOR LAYUP. TRIM AND DRILL PER DT8619
- 2) RESIN: DERAKANE 411/510A40/470-36
- 3) FOAM: 3/8" A500 CORE CELL OR DMVYCELL OR AIREX OR KLEGECCELL R-75
- 4) FIBRE: 9.7 oz 7781 WEAVE "S" GLASS ("9 oz SATIN")
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
- 5) BOND FOAM CORE TO LAMINATE USING POLYBOND B46F
- 6) LAMINATE LABEL USING SURFACE VEIL AND EPOXY RESIN.
- 7) LAMINATE PER DART QSI 006 4.0
- 8) LAMINATION SCHEDULE PER THIS DRAWING
- 9) FINISH INSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 10) ALL DIMENSIONS ARE IN INCHES
- 11) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER
NO. 41139

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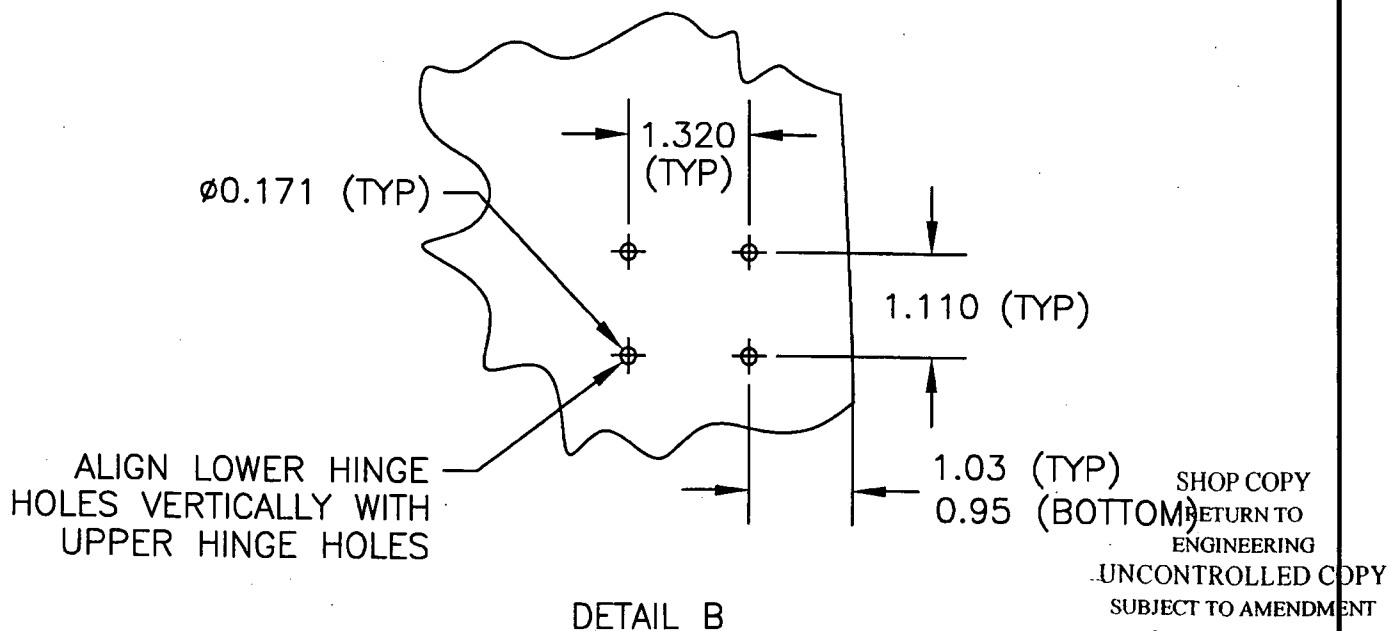
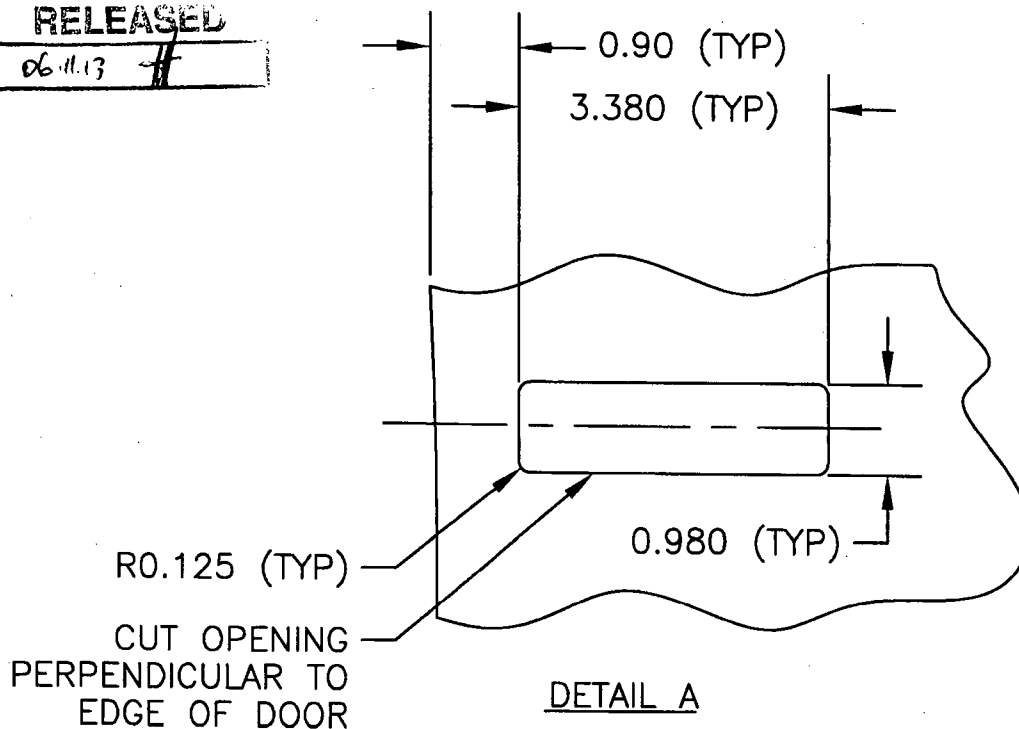
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DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2445	REV. D SHEET 2 OF 2
DATE 06.06.09	TITLE AFT BAGGAGE DOOR		SCALE 1:2

RELEASED

06.11.13 [Signature]



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3.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

3.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	½" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER
4	4	AN960JD10	WASHER
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08)
4	4	MS21042L3	NUT (or MS21042-3)
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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SUBJECT TO AMENDMENT
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Revision: D

Date: 02.01.170

WORK ORDER

47739



DELASTEK COMPOSITES INC.
2699, 5^{ème} Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	13033
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:


Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200


Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
PURO COLLECT		Point de départ		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
24/11/2008	24/10/2008	5918	Chantal Lavoie		00006919		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC-SAV-AERONAUTIQUE	D350-588-041 Aft Baggage Door (D2445) B41139 ✓ DKC134-0013 RNC Delastek: SCD-0279 JOB: 43440 			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:


Quality department AQ-357

Mardi, 2008-10-28 10:07:21

Marc Dubé

Feuille de Procédé

Client : DART Dart Aerospace Ltd.
 Numéro Job : 43440
 Numéro Soumission : 2017
 Numéro B.A. :
 Date de Rev. : 2008-10-28 No. B.V. :
 Révisé : NC
 Date de Rev. : - - Type :
 Numéro précédent : 43409

Nom Dessin : AFT BAGGAGE DOOR D2445
 Numéro Article : DKC134-0013
 Numéro Dessin : D2445
 Projet Numéro : DKC134
 Révision dessin : D
 Matériel : Fibre 7781 et Résine 411-350
 Date Due : 2008-11-04

Qté: 1 Udm: UNITE

Approuvé par :
 Commentaires : N° de pièce Dart Aérospace: D2445
 N° Delastek Composites: DKC134-0013
 N° de projet Delastek: DK-362

Process Sheet Rév.: 10 Modification du planning afin d'y inclure le
 N° I.G 0008 (Primer)

Produit additionnel

Numéro Job:



Séq.: Machine ou Opération: Description :

1.0 AC0303 Frekote 44NC

Commentaire Qty.: 0.020 GALLON(s)/Unit Total : 0.020 GALLON(s)
 Frekote 44NC

2.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
 PRÉPARATION DU MATÉRIEL DART

Faire la préparation du moule N° DT-8036 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon
 le QSI-006.

Date: _____ Heure Début: _____ Heure Fin: _____ Scé: _____

3.0 AAC0273 Gel Coat Blanc N° Gel 94W005

Commentaire Qty.: 0.200 GALLON(s)/Unit Total : 0.200 GALLON(s)
 Gel Coat Blanc N° Gel 94W005

N° de Lot: 1-6828-3

4.0 AAC0275 Catalyst N° DDM-9

Commentaire Qty.: 0.0320 PINTE(s)/Unit Total : 0.0320 PINTE(s)
 Catalyst N° DDM-9

N° de Lot: 1-6270-1

Date: Mardi, 2008-10-28 10:07:21

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 43440

Nom Design: AFT BAGGAGE DOOR D2445
Numéro Article: DKC134-0013

Numéro Job:



Séq.: Machine ou Opération:

5.0 AC0260 Acetone

Description :

Commentaire Qty.: 0.125 KILOGRAMME(s)/Unit Total : 0.125 KILOGRAMME(s)
Acetone

6.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation du matériel :

Dans une quantité de 0.2 gallon de Gel Coat N° 944W005 ajouter 10% de Catalyst N° DDM-9 et diluer à l'aide de 10% D'acétone.

Date: 6-11-08 Sceau:  Temps Début: 9:00 Temps Fin: 9:15

7.0 GEL COAT. APPLICATION DE GEL COAT



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
APPLICATION DE GEL COAT

À l'aide d'un fusil à peinture appliquer une couche entre 15 et 20 millièmes de Gel Coat sur le moule N° DT8036 et laisser sécher pendant un minimum de 12 heures avant de faire le lay-up, mais ne pas dépasser 24 heures de séchage selon l'instruction de travail N° Tec-70.

Note: Le gel coat ne doit contenir aucun "airdry" ni aucune cire. Le temps de séchage est important afin d'éviter d'avoir des défauts de surface, et afin d'éviter que le tissu ne vienne marquer au travers du Gel Coat ainsi que d'éviter d'avoir un rétrécissement.

Autocontrôle de fabrication. (Visuel du Gel Coat)

Date: 6-11-08 Sceau:  Temps Début: 9:15 Temps Fin: 9:30

8.0 AC0409 Tissu à délaminer Release ply B

Commentaire Qty.: 1.52 VERGE(s)/Unit Total : 1.52 VERGE(s)
Tissu à délaminer Release ply B

9.0 AC0407 Wrightlon 5200 Bleu P3

Commentaire Qty.: 3.33 VERGE(s)/Unit Total : 3.33 VERGE(s)
Wrightlon 5200 Bleu P3

10.0 AC0408 Feutre de drainage N° Airweave N 10

Commentaire Qty.: 2.78 VERGE(s)/Unit Total : 2.78 VERGE(s)
Feutre de drainage N° Airweave N 10

Date: Mardi, 2008-10-28 10:07:21
Utilisateur: Marc Dubé

Feuille de Procédure

Client: DART Dart Aerospace Ltd.
Numéro Job: 43440

Nom Description: AFT BAGGAGE DOOR D2445
Numéro Article: DKC134-0013

Numéro Job:



Séq.: Machine ou Opération:

Description:

11.0 AC0752 Stretchlon 200 poche à vide Vert

Commentaire Qty.: 2.00 PIED(s)/Unit Total: 2.00 PIED(s)
Stretchlon 200 poche à vide Vert

12.0 AAC0326 9.7 oz Weave "S" glass #FG-778150-125Y

-778150-125Y Volan Finish

Commentaire Qty.: 2.0 VERGE(s)/Unit Total: 2.0 VERGE(s)
9.7 oz 7781 Weave "S" glass #FG-778150-125Y

N° de Lot: 1-6582-1

13.0 AAC0443 Fiberglass 12 oz Unidirectional

Commentaire Qty.: 0.33 VERGE CAR(s)/Unit Total: 0.33 VERGE CAR(s)
Fiberglass 12 oz Unidirectional

N° de Lot: 1-21729-1

14.0 AC0098 Ruban à gommer jaune #T/AT-200Y

/AT-200Y

Commentaire Qty.: 1.2500 RL(s)/Unit Total: 1.2500 RL(s)
Ruban à gommer jaune #: T/AT-200Y

15.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 20.0000Min Total Run: 0.3333Hrs
PRÉPARATION DU MATÉRIEL DART

Tailler le matériel, selon les différents patrons de découpe comme suit:

4 plis de tissus de 9.7 oz.

1 pli de 12 oz. pour tout le contour de la pièce par 5" de large.

3 fois le sac à vide Stretchlon 200.

3 fois le film perforé P-3

3 fois le feutre de drainage

2 fois le tissu à délaminer (non nécessaire lors du bagging du contour).

Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le côté non en contact avec le sac à vide.

Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps, en les superposant les uns sur les autres.

Date: 01-10-08 Heure Début: 9:00 Heure Fin: 9:20



16.0 AAC0275 Catalyst N° DDM-9




Commentaire Qty.: 0.0120 PINTE(s)/Unit Total: 0.0120 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 1-6270-1

Date: Mardi, 2008-10-28 10:07:21

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Description: AFT BAGGAGE DOOR D2445
Numéro Job: 43440		Numéro Article: DKC134-0013
Numéro Job: 		
# Séq.:	Machine ou Opération:	Description :
21.0	AAC0275 Catalyst N° DDM-9	
Commentaire Qty.: 0.0042 PINTE(s)/Unit Total : 0.0042 PINTE(s) Catalyst N° DDM-9		
N° de Lot: 1-6270-1		
22.0	AAC0324 Résine (411B7530) 411-3	promo. 75min.
Commentaire Qty.: 0.120 KILOGRAMME(s)/Unit Total : 0.120 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min.		
N° de Lot: 1-22263-1		
23.0	PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART	
Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs PRÉPARATION DU MATÉRIEL DART		
Faire la préparation de la résine selon les quantités requise, mixer 2% de catalyst N° DDM-9 par quantité de résine N° 411-350, Imbiber toutes les surfaces du Foam Core.		
Laisser sécher pendant 1 heure.		
Date: 2-10-08 Heure Début: 1:35 Heure Fin: 1:45		
24.0	AAC0452 Polybond B46F	
Commentaire Qty.: 0.045 KIT(s)/Unit Total : 0.045 KIT(s) Polybond B46F		
N° de Lot: 1-6520-1		
25.0	DKC134-0029 Foam Core N° D2445-10	Pour AFT Baggage Door)
Commentaire Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s) Foam Core N° D2445-101 (Pour AFT Baggage Door)		
26.0	ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRAL DART	
Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs ASSEMBLAGE GÉNÉRAL DART		
Retirez le bagging.		
Appliquer une couche de polybond B46F à l'endos du foam core DKC134-0029 et positionner le foam sur le moule selon le dessin et selon les lignes de positionnement prévues à cet effet.		
Date: 11-11-08 Heure Début: 11:30 Heure Fin: 11:45		



Date: Mardi, 2008-10-28 10:07:21
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 43440

Nom Description: AFT BAGGAGE DOOR D2445
Numéro Article: DKC134-0013

Numéro Job:



Séq.: Machine ou Opération:

27.0 POCHE À VIDE 1 FAIRE LA POCHE À VIDE



Description:




Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
FAIRE LA POCHE À VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Film Perforé P-3.
- 2- Feutre de drainage
- 3- Sac à vide Stretchlon 200.

Laisser sécher pendant 2 heures minimum.

Date: 11-11-08 Heure Début: 11:45 Heure Fin: 11:50 Scellé: 



Curing Début: 11:30 Curing Fin: 1:10

28.0 AAC0275 Catalyst N° DDM-9

Commentaire Qty.: 0.0136 PINTE(s)/Unit Total : 0.0136 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 1-6118-3

29.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 0.360 KILOGRAMME(s)/Unit Total : 0.360 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.


N° de Lot: 1-22370-1

30.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL DART

Faire la préparation de la résine selon les quantités requises, mixé à 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 13-11-08 Heure Début: 12:30 Heure Fin: 12:35 Scellé: 

31.0 LAMINAGE. LAMINAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
LAMINAGE PIÈCE DART

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage du plis de tissu 12 oz. tout le tour de la porte en prenant bien soin que les deux bandes

Date: Mardi, 2008-10-28 10:07:21
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 43440

Nom Description: AFT BAGGAGE DOOR D2445
Numéro Article: DKC134-0013

Numéro Job:



Séq.: Machine ou Opération:

Description :

allant dans le coin droit en bas se superposent

Faire le laminage du dernier pli de 9.7 oz.

Date: 13-11-08 Heure Début: 12:35 Heure Fin: 1:05 Sce. I:

32.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
FAIRE LA POCHE À VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer.
- 2- Film perforé P-3.
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200.

Laisser sécher pendant 4 heures minimum.

Date: 13-11-08 Heure Début: 1:05 Heure Fin: 1:15 Sce. I:

Curing Début: 12:35 Curing Fin: 8:00

33.0

DÉMOULAGE 1

DÉMOULAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
DÉMOULAGE PIÈCE DART

Démouler la pièce en faisant bien attention de ne pas abimer les coins et les " edges ".

Date: 17-11-08 Heure Début: 9:20 Heure Fin: 9:25 Sce. I:

34.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
TRIMAGE COMPOSITES DART

À l'aide du gabarit N°DT 8619 trimer la pièce en utilisant un router muni d'un couteau 1/4" et d'un " Bushing " 1/16" de mur.

Percer les " Latch " et les trous de penture selon le dessin N° D24 5.

Date: 17-11-08 Heure Début: 2:00 Heure Fin: 2:30 Sce. I:

Date: Mardi, 2008-10-28 10:07:21
Utilisateur: Marc Dubé

Feuille de Procédure

Client: DART Dart Aerospace Ltd.
Numéro Job: 43440

Nom Description: AFT BAGGAGE DOOR D2445
Numéro Article: DKC134-0013

Numéro Job:



Séq.: Machine ou Opération:

35.0 AAC0062 Label N° D0588-041

Commentaire Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)
Label N° D0588-041

36.0 AAC0444 Surface Veil

Commentaire Qty.: 0.07 VERGE CAR(s)/Unit Total: 0.07 VERGE CAR(s)
Surface Veil

37.0 AAC0501 Résine Mia-Poxy

Commentaire Qty.: 0.007 GALLON(s)/Unit Total: 0.007 GALLON(s)
Résine Mia-Poxy

38.0 AAC0502 Durcisseur 95 Pour Résine Mia-Poxy

Commentaire Qty.: 0.007 PINTE(s)/Unit Total: 0.007 PINTE(s)
Durcisseur 95 Pour Résine Mia-Poxy

39.0 FAB GÉNÉRALE 3 FABRICATION GÉNÉRALE DART



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs
FABRICATION GÉNÉRALE DART

Coller le label N° D0588-041 selon les séquences suivantes:

- 1- Surface Veil
- 2- Label
- 3- Surface Veil

Laisser sécher pendant 4 heures.

Date: 18-11-08 Heure Début: 3.55 Heure Fin: 4.10



40.0 AC0058 Polysoft 1.3 kg # 003012 Sikkens

Commentaire Qty.: 0.025 UNITE(s)/Unit Total: 0.025 UNITE(s)
Polysoft 1.3 kg # 003012 Sikkens

N° de Lot: 1-6782-1

41.0 AC0059 Durcisseur Polysoft #00409 Sikkens

Commentaire Qty.: 0.020 UNITE(s)/Unit Total: 0.020 UNITE(s)
Durcisseur Polysoft #00409 Sikkens

42.0 FINITION 3 FINITION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run: 0.1667Hrs
FINITION PIÈCE DART

Faire les réparation de finition s'il y a lieu à l'aide du Sikkens.









Date: 17-11-08 Heure Début: 2.40 Heure Fin: 3.00



Date: Mardi, 2008-10-28 10:07:21

Utilisateur: Marc Dubé

Feuille de Procédure

Client: DART Dart Aerospace Ltd.		Nom Descriptif: AFT BAGGAGE DOOR D2445
Numéro Job: 43440		Numéro Article: DKC134-0013
Numéro Job: 		
# Séq.:	Machin ou Opération:	Description:
43.0	AAC0683 Dupont Primer N° 7704S	
Commentaire Qty.: 0.0280 UNITE(s)/Unit Total: 0.0280 UNITE(s) Dupont Primer N° 7704S N° de Lot: 21492		
44.0	AAC0685 Dupont Activator - Reducer	Chromabase N° 7775S
Commentaire Qty.: 0.0283 UNITE(s)/Unit Total: 0.0283 UNITE(s) Dupont Activator - Reducer Chromabase N° 7775S 1- 1492-4		
45.0	PRIMER APPLICATION DE PRIMER	
Commentaire Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run: 0.0000Hrs APPLICATION DE PRIMER Appliquer le primer selon I.G. 0008 Quantité: 1 Date: 18/11/08 Sceau:  Quantité: 1 Date: NOV 19 2008 Sceau:  Quantité: Date: Sceau: Quantité: Date: Sceau:		
46.0	INSPECTION 3 INSPECTION PIÈCE DART	
Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs INSPECTION PIÈCE DART Faire l'inspection selon le dessin N° D2445. Date: 20-11-08 Heure Début: — Heure Fin: — Sceau: 		
47.0	EMBALLAGE EMBALLAGE ET ENTREPOSAGE	
Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs EMBALLAGE ET ENTREPOSAGE Faire l'emballage des pièces. Quantité: 1 Date: 20-11-08 Sceau:  Quantité: Date: Sceau:		

N/S: B 41139

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Date: Monday, 11/08/2008 2:46:41 PM
 By: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : AFT DOOR ASSEMBLY
 Job Number : 41139
 Estimate Number : 12103
 P.O. Number :
 Date of Issue : 11/08/2008 S.O. No. :
 Revision : NC
 First Issue : / / Type : SMALL /MED FAB
 Previous Run : 36869
 Part Number : D350588041
 Drawing Number : D2445, D350-588 P5-6
 Project Number : N/A
 Drawing Revision : D,D
 Material :
 Due Date : 12/09/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : JD 08-8-11
 Comment : Est P 04.02.04 Reformat KJ/DS

Additional Product

REFERENCE ONLY

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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JD 08-8-26



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D350-588-041 CHG003

2.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: _____

Description: D2445 Baggage Door

Supplier: Delastek

Ship to Delastek (1) D0588-041 label

Certification of Conformity and process sheet from Delastek is required.

3.0	D2445	Aft Door, 350
-----	-------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Aft Door

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure Certificate of Conformity & Process Sheet are attached

5.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: INSPECT WORK TO CURRENT STEP

Inspect as per Dwg D2445.

Audit process sheet.